

20

5th

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20651
<b>Description:</b> Bearpaw Kit (48" x 19") 205/430	<b>Part Number:</b>	K10015
<b>Dwg:</b> D2521 Rev. H	<b>Qty:</b>	10 Kits
<b>Ref:</b> K10015 Rev. A; DSK086-6 Rev. A	Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler <b>Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required</b>	HJ	04.04.01	10																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 <b>(Bag Bluefiles separately)</b>	UK 18 HJ	04.04.30	10																																								
3	GA	<b>Cut 2 blanks per (1) K10015 Kit</b> Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M1486Y</u>	ED	04/04/26	10																																								
4	MV	Inspect material for defects or damage prior to machining	ED	04/04/26	10																																								
5	MV	Machine as per Folio FA222 and Dwg D2521 <b>Identify as D2521</b>	ED	04/04/30	10																																								
6	QC2	Inspect parts as they come off the CNC machine	ED	04/04/30	10																																								
7	MV	Deburr	ED	04/04/30	10																																								
8	MV	Form as per Dwg D2521 using bending Jig DT8328	ED	04/04/30	10																																								
9	QC8 & 5	Second inspection	ED	04/05/03	10																																								
10	KP	<b>Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3)</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>8 ✓</td><td>D2182B055</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>16 ✓</td><td>D2274</td><td>Radius Block</td><td>B20655</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B20651</td></tr><tr><td>16 ✓</td><td>D2529</td><td>Washer</td><td>B20388</td></tr><tr><td>8 ✓</td><td>D2947</td><td>Clamp</td><td>BH106/B 19991</td></tr><tr><td>16 ✓</td><td>AN4-15A</td><td>Bolt</td><td>M14544</td></tr><tr><td>16 ✓</td><td>AN960JD416</td><td>Washer</td><td>M14312</td></tr><tr><td>16 ✓</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M14149</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2 ✓</td></tr></tbody></table>	Qty	Part Number	Description	Batch	8 ✓	D2182B055	Rubber Cushion	B20434	16 ✓	D2274	Radius Block	B20655	2	D2521	Bearpaw	B20651	16 ✓	D2529	Washer	B20388	8 ✓	D2947	Clamp	BH106/B 19991	16 ✓	AN4-15A	Bolt	M14544	16 ✓	AN960JD416	Washer	M14312	16 ✓	MS21042L4	Nut (or -4)	M14149	1	Paperwork package from Step 2 ✓			ED	04/05/03	10
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1	Paperwork package from Step 2 ✓																																												
11	QC4	Inspect Kit for 100% Completeness on the W/O	U	04/05/04	10																																								
12	PK	Identify and pack for shipping as per PPP K10015	U	04/05/04	10																																								
13	AC	Cost / part <u>366.17</u>	SUF	04.05.05	10																																								
14	DC	Close W/O <u>366.26</u> Inspect Level 21.	HJ	04.05.06	10																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	

BB 04-05-05 BB

RELEASED  
04.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20651		WORK ORDER NON-CONFORMANCE K10015						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04-07-29	5	- Bottom aft area of bearpaw damaged, one (1) part affected	#	Blend damaged area to a smooth finish Make a matching bearpaw.	E 04.07.30 E 04.07.30	B 04-05-03	# 04.04.30	# 04-05-03

PAR#: N/A.Fault Category: manuf-cncDQA: LDDate: 04-05-06

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: LDDate: 04.05.06

re-work  
- repair

DART AEROSPACE LTD		Work Order:	20651
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: H		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.002	✓		vern	
B	5.600	+/-0.030	5.595	✓		vern	
C	11.500	+/-0.030	11.500	✓		12" vern	
D	10.250	+/-0.010	10.260	✓		12" vern	
E	13.250	+/-0.010	13.250	✓		tape measure	
F	8.500	+/-0.010	8.500	✓		12" vern	
G	22.125	+/-0.030	22.125	✓		tape measure	
H	8.75	+/-0.010	8.74	✓		12" vern	
I	44.500	+/-0.030	44.500	✓		tape measure	
J	6.688	+/-0.030	6.691	✓		12" vern	
K	5.625	+/-0.030	5.612	✓		vern	
L	7.000	+/-0.030	7.016	✓		12" vern	
M	5.000	+/-0.010	5.000	✓		vern	
N	4.000	+/-0.030	3.990	✓		vern	
O	6.625	+/-0.030	6.638	✓		12" vern	
P	19.000	+/-0.030	19.000	✓		tape measure	
Q	0.31 x 45°	+/-0.030	0.31 x 45°	✓		vern	
R	0.19 x 45°	+/-0.030	0.1845 x 45°	✓		vern	
S	0.50 x 45°	+/-0.030	0.50 x 45°	✓		vern	
T	0.38 x 45°	+/-0.030	0.38 x 45°	✓		vern	
U	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		vern	
V	Ø0.260	+0.005/-0.000	Ø0.260	✓		vern	
W	Ø0.93	+/-0.030	Ø0.932	✓		vern	
X	0.30	+0.030/-0.010	0.305	✓		vern	
Y	0.375	+/-0.010	0.381	✓		vern	
Z	0.750	+/-0.030	0.750	✓		vern	
AA	0.250	+/-0.010	0.257	✓		vern	
AB	4.000	+/-0.030	same as "N"				
AC	6.625	+/-0.030	same as "O"				
AD	0.950	+0.030/-0.010	0.965	✓		vern	
AE	0.375	+/-0.010	0.375	✓		vern	
AF	3.399	+/-0.030	3.399	✓		vern	
AG	6.625	+/-0.030	6.620	✓		12" vern	

Measured by: <i>ED</i>	Audited by: <i>R</i>	Prototype Approval:	N/A
Date: 04/04/27	Date: 04.04.27	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O K10015	KJ/RF

RELEASED

04.01.15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 01, 2004  
02:23 pm

Work Order No : 0020651  
Project Name : \*K10015  
Project For : WK420  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*K10015  
Description : Bearpaw Kit  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 04-01-04  
Est Finish Date : 05-13-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00